

466 BLUE

Dart Aerospace Ltd.

Date: Tuesday, 14/10/2008 1:24:30 PM  
 User: Julie Lecocq

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : 206 L HIGH GEAR SKIDTUBE
<b>Job Number</b> : 42580A	
<b>Estimate Number</b> : 10522	
<b>P.O. Number</b> :	<b>Part Number</b> : D206642441
<b>This Issue</b> : 14/10/2008 <b>S.O. No.</b> :	<b>Drawing Number</b> : D2650 REV E
<b>Prsht Rev.</b> : NC	<b>Project Number</b> :
<b>First Issue</b> : 14/10/2008 <b>Type</b> : SKIDTUBES	<b>Drawing Revision</b> : E
<b>Previous Run</b> : 41321A	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 04/11/2008 <b>Qty:</b> 1 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>JUL 08.10.14</u>	
<b>Comment</b> : Est Rev: H 05.10.11 Added D3429-1 per CHG002 KJ/CP/JLM Est Rev: I 08-05-01 add QC3 DD verified by: EC	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	DC	DOCUMENT CONTROL
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**Comment:** DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D206-642-441 CHG002

N/A

2.0	D2620	Skidtube, 206 Skidtube
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number	Description	Batch
1 D2620	Bent Tube 3" OD	B 40820

JP 8-10-16

3.0	D2647	Cap
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number	Description	Batch
1 D2647	Fwd Cap	25475 BE 8-10-20

4.0	SKIDTUBES 1	SKIDTUBESS RESOURCE 1
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**Comment:** LANDING GEAR RESOURCE 1

1-Deburr Fwd edge of tube

JP 8-10-16

2-Remove ridge on inside of Fwd edge of tube as per Dwg D2650

3-Weld Fwd Cap as per Dwg D2650. Use aluminum rod. Grind D2647 to fit as required.

A/R Aluminum Rod m 109213 BE 8-10-20

4-Grind weld flush to cap on top surface only.

BE 8-10-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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## Process Sheet

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Drawing Name: 206 L HIGH GEAR SKIDTUBE

Job Number: 42580A

Part Number: D206642441

Job Number:



Seq. #:

Machine Or Operation:

Description :

5-Cut aft end 138.60" from front of tube

6-Drill pilot holes using drill jig DT8025 & DT8169 (A,B,C,D). Open to Ø0.312".

7-Drill holes for wearplates using DT 8028-7. Open to Ø 0.297".

8-Open using #6 Drill Bit

9-Open holes for Tow Ring to Ø0.625" as per Dwg D2650, D2650-7 Drilling Detail

JP 8-10-23

10-Remove inner indexing ridge on aft end of skidtubes per Dwg D2650

11-Deburr and Blow out all chips form inside the tube

5.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

JP 8-10-23

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

D 8-10-23

7.0

D26547

Web



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2654-7

Web

B-26547

AWM 8-10-23

8.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open holes to finished size as per Dwg D2650, D2650-7 Drilling Detail (without cutting fluid)

2-Countersink crossbolt spacer holes as per Dwg D2650(without cutting fluid)

3-Deburr. Blow out chips. Grind alodine off around crossbolt spacer.

4-Bond D2654-7 web in place as per QSI 015Ensure holes line upAllow 12 Hrs. cure time before cutting

Start Date: 8-10-23

Time: 2:33

Finish Date: 8/10/26

Time: 7:20 AM

JP 8-10-23

AWM 8-10-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 42580A

Part Number: D206642441

Job Number:



Seq. #:

Machine Or Operation:

Description:

A/R Sikaflex-291

Sikaflex expiry date:

~~10~~ M109449  
8-11-01

AWM 8-10-23

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

508/10/28 (40)

10.0

D2649

Cross Bolt Spacer



Comment: Qty.: 23.0000 Each(s)/Unit Total: 23.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

23 D2649

Crossbolt spacer

B 41594 (9) B42 622 (14)

M 8-10-28

11.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Insert cross bolt spacers D2649. Weld as per QSI 004 and Dwg D2650. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod.

A/R Aluminum Rod

M109213 AC 8-10-28

2-Grind welds flush as per Dwg D2650. Masking Tape access to inside of the Skidtube

M 8-10-28

3-Counterbore 5/16" x 0.750" deep as per Dwg D2650Debur

JD 8-10-30

12.0

D2680041

Nut Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2680-041

Nut Plate

B 34599

JD 8-10-30

13.0

CCR264SS33

Cherry Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 CCR264SS3-3

Rivets

109431

JD 8-10-30

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 42580A

Part Number: D206642441

Job Number:



Seq. #: Machine Or Operation: Description :

14.0

M7885343

Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 M7885/3-4-3

Rivets 106 167

JB 8-10-30

15.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Install D2680-041 Nut Plate as per Dwg D2650

JB 8-10-30

16.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

S 08/10/30 (X)

17.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/10/30 (X)

18.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Pressure wash as per QSI 005

JB

08-10-30 (X)

19.0

SPRAY PAINTING

SPRAY PAINTING



Comment:

-PRIME

-SPRAY PAINT DELFLEET BLUE

-CLEAR DELFLEET

B 109400

B 105918

B 109333

> M 08 11 06 (1)

20.0

QC14

INSPECT SPRAY PAINT



Comment: INSPECT SPRAY PAINT

08-11-07 (1)

21.0

D26483

Wearpad



Comment: Qty.: 6.0000 Each(s)/Unit Total: 6.0000 Each(s)

Pick:

Qty Part Number

Description Batch

6 D2648-3

Wearpad B 41436

JB 08-11-11 (X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 42580A

Part Number: D206642441

Job Number:



Seq. #:	Machine Or Operation:	Description :
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22.0

D265615

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2656-15

Wearshoe B41125

*JS*

23.0

D265623

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2656-23

Wearshoe B34597

*JS*

24.0

D265637

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2656-37

Wearshoe B341634

*JS*

25.0

D34291

Wearpad



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D3429-1

Wearpad B341042

*JS*

26.0

ALS41032130

Insert



Comment: Qty.: 60.0000 Each(s)/Unit Total : 60.0000 Each(s)

Pick:

Qty Part Number

Description Batch

60 ALS4-1032-130

Inserts M105819

or (see QSI 017)

*JS* 08-11-11 - *(R1)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 42580A

Part Number: D206642441

Job Number:



Seq. #:	Machine Or Operation:	Description :
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27.0	AN960JD10L	Washer
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Comment: Qty.: 62.0000 Each(s)/Unit Total : 62.0000 Each(s)

Pick:

Qty Part Number Description Batch

60 AN960JD10L Washer 1A 105793 *MS*

28.0	MS27039108	Screw
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Comment: Qty.: 62.0000 Each(s)/Unit Total : 62.0000 Each(s)

Pick:

Qty Part Number Description Batch

62 MS27039-1-08 Screw 1A 107378 (K12)  
1A 109061 (R50) MS

29.0	D26511	Plug
------	--------	------



Comment: Qty.: 22.0000 Each(s)/Unit Total : 22.0000 Each(s)

Pick:

Qty Part Number Description Batch

22 D2651-1 BLUE Plugs 1342564 *MS*

30.0	D26513	O-Ring
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Comment: Qty.: 22.0000 Each(s)/Unit Total : 22.0000 Each(s)

Pick:

Qty Part Number Description Batch

22 D2651-3 O-Rings 1341124 *MS*

31.0	AN960JD416	Washer
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 AN960JD416 Washer 1A 108161 *MS*

08-11-11 *MS*

51  
66  
12  
38

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 42580A

Part Number: D206642441

Job Number:



Seq. #: Machine Or Operation: Description :

32.0 MS27039406 Screw



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 MS27039-4-06 Screw M1109061 JH

33.0 D2646 Aft Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2646 BLUE Aft Cap B341435 JH

34.0 HAND FINISHING1 HAND FINISHING-RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Install inserts & wearpads as per dwg D2922. Use a drop of Sikaflex inside insert holes before installing wearpad/wearplate.

A/R Sikaflex-291 M1107062

Sikaflex expiry date: 08/11

2-Install O-Rings D2651-3 on plugs D2651-1 with Petroleum Jelly and install plugs as per Dwg D2650. Clean excess adhesive

3-Install MS27039-4-06 Screw as per DEO 9153

4-Inspect for foreign object per QSI 024

5-Install D2646 Aft Cap and seal with SikaflexClean excess adhesive

A/R Sikaflex-291 M1107062

Sikaflex expiry date: 08/11

6-Wing Walk as per Dwg D2650-7 and QSI 005 4.4

Batch: M109219

FL 08/11/10

B

35.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/11/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 42580A

Part Number: D206642441

Job Number:



Seq. #:

Machine Or Operation:

Description :

36.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: MM 42580

*Le Guec*

37.0

QC21

FINAL INSPECTION/W/O RELEASE



08/11/12 *gg*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



*U 08-11-12*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



NO. 178

**AWS D17.1.2001**  
**QUALIFICATION TEST RECORD**

Name: Barclay Elliot  
Job number: B42165A  
Part number: A206-6642-541  
Description: SKILLUP  
Welding Process: Tig[☒] Mig[ ]  
Base material: Alum  
Current: AC[☒] DC[ ]

**TEST REQUIREMENTS AND RESULTS**

Visual: pass[☒] fail[ ]  
Penetration: pass[☒] fail[ ]

**UNACCEPTABLE**

Cracks: pass[☒] fail[ ]  
Undercut: pass[☒] fail[ ]  
Pin holes: pass[☒] fail[ ]  
Overlap (cold lap): pass[☒] fail[ ]  
Porosity (surface): pass[☒] fail[ ]  
Coloration: pass[☒] fail[ ]

Qualifier David David Date of Test Coupon 08/10/20

Welder Barclay Elliot Date of Test Coupon 08/10/20

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

QTY -1	QTY -3	QTY -5	QTY -7	PART NUMBER	DESCRIPTION
X				D2650-1	SKIDTUBE ASSEMBLY
	X			D2650-3	SKIDTUBE ASSEMBLY
		X		D2650-5	SKIDTUBE ASSEMBLY
			X	D2650-7	SKIDTUBE ASSEMBLY
1	1	1	1	D2600-1-160	EXTRUSION
1				D2654-1	WEB
	1			D2654-3	WEB
		1		D2654-5	WEB
			1	D2654-7	WEB
1	1	1	1	D2646	AFT CAP
1	1	1	1	D2647	CAP
17	18	19	23	D2649	CROSS BOLT SPACER
16	18	14	22	D2651-1	PLUG
16	18	14	22	D2651-3	O-RING
1	1	1	1	D2680-041	NUT PLATE
2	2			D3286-1	DOUBLER
2	2			D3286-3	STUD
42	44	54	60	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, ALS7-1032-130)
2	2	2	2	AN960JD10L	WASHER
2	2	2	2	CCR264SS3-3	RIVET
2	2	2	2	CR3212-4-03	RIVET
2	2	2	2	MS27039-1-08	SCREW
1	1	1	1	MS27039-4-06	SCREW
1	1	1	1	AN960JD416	WASHER
52	52			CR3212-4-04	RIVET

F

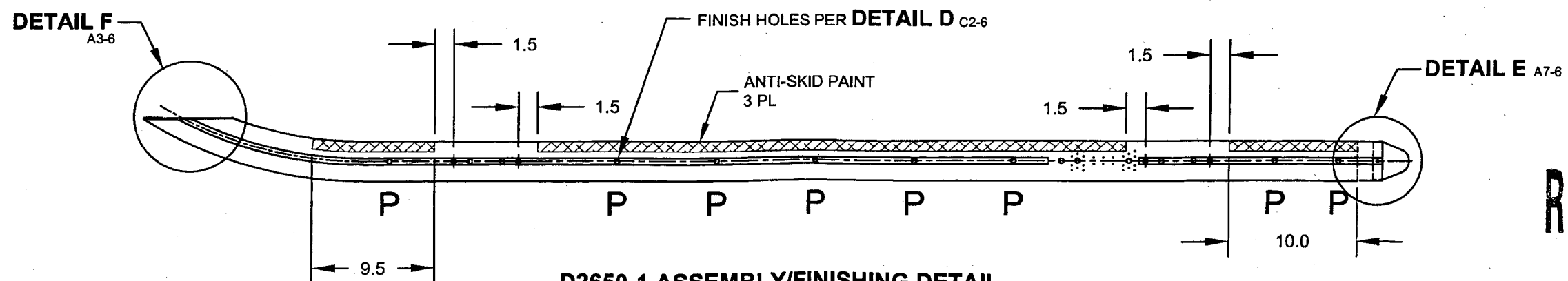
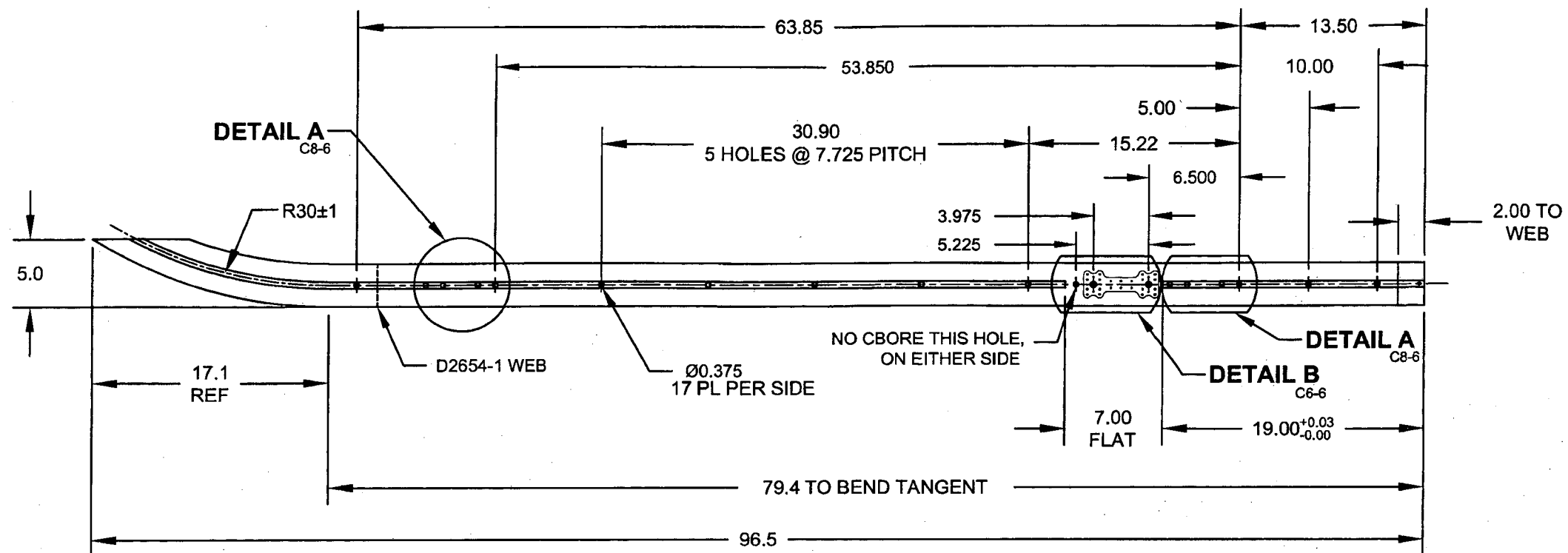
F

#### NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3  
-BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) WELD PER DART QSI 004
- 9) DAMAGE TOLERANCE ON FWD BEND:  
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- 10) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015
- 11) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)
- 12) DRILL Ø0.297 FOR ALS7-1032-130 INSERTS USING TEMPLATE DT8056-1 ON -1 TUBE, DT8056-3 ON -3 TUBE, DT8056-5 ON -5 TUBE, AND DT8056-7 ON -7 TUBE. INSTALL INSERTS AFTER FINISH.
- 13) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED





SHOP COPY  
RETURN TO  
ENGINEERING  
CONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 425804

F	DRAWING UPDATED TO CURRENT STANDARDS. SHT 6 ADDED. ALL SECTION AND DETAIL VIEWS TRANSFERRED TO SHT 6. SHT 1 IN PL PART D2649 QTY UPDATED. SHT 6 SECT C-C GRIND INSTRUCTIONS DELETED FROM NOTE 7 (SEE NCR 239).	AJS	08.08.08
E	RMOVE CBORE, CHG DRILL, ADD CHAMFER	CP	06.03.30
D	REDRAW; INCCORP. DE09136/9153/9163 MOD GROUND HANDLING ON D2650-1/-3	CP	04.05.17
C	CHANGE HOLE PATTERN AND FRONT END	DS	97.10.29
B	AS MANUFACTURED CHANGES	DS	97.06.26
A	NEW ISSUE	DS	97.03.25
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	<b>DART AEROSPACE USA, INC</b>	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 1 OF 6
APPROVED		TITLE	SCALE
DE APPR.		206/407 SKIDTUBE ASSEMBLIES	NTS
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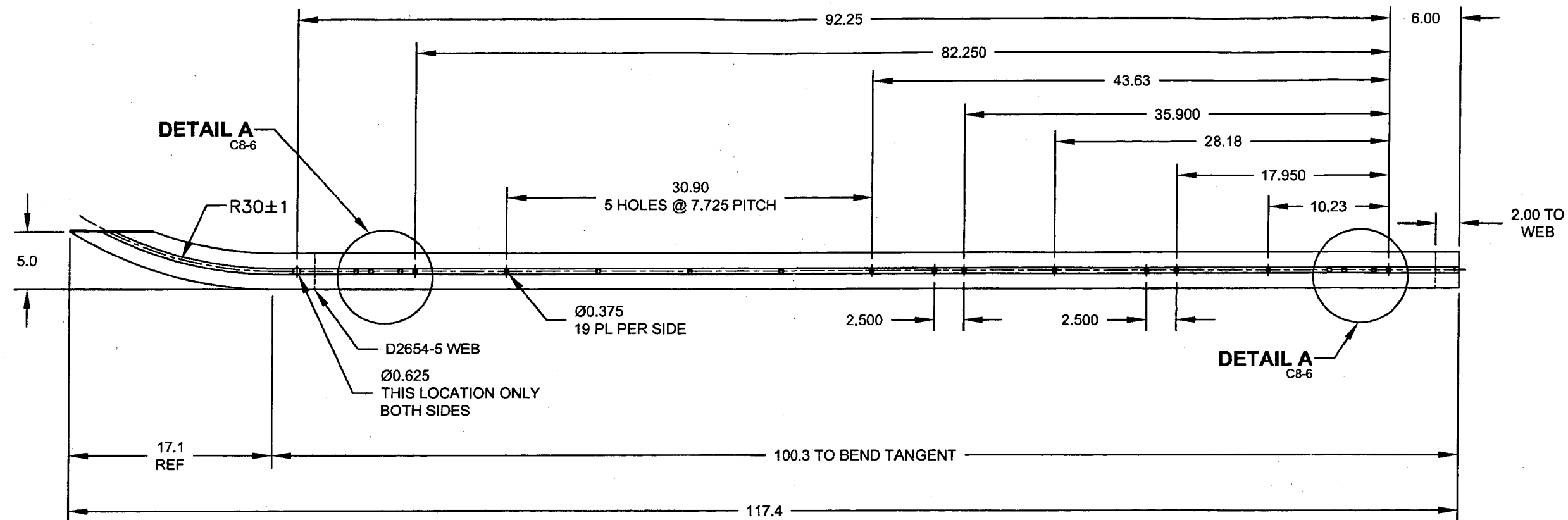


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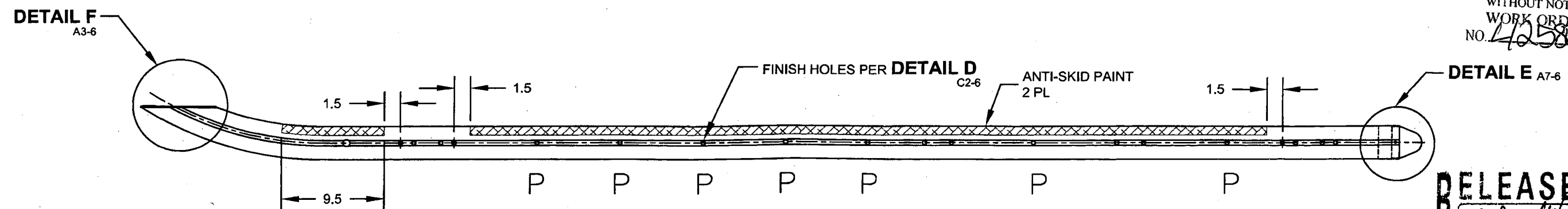
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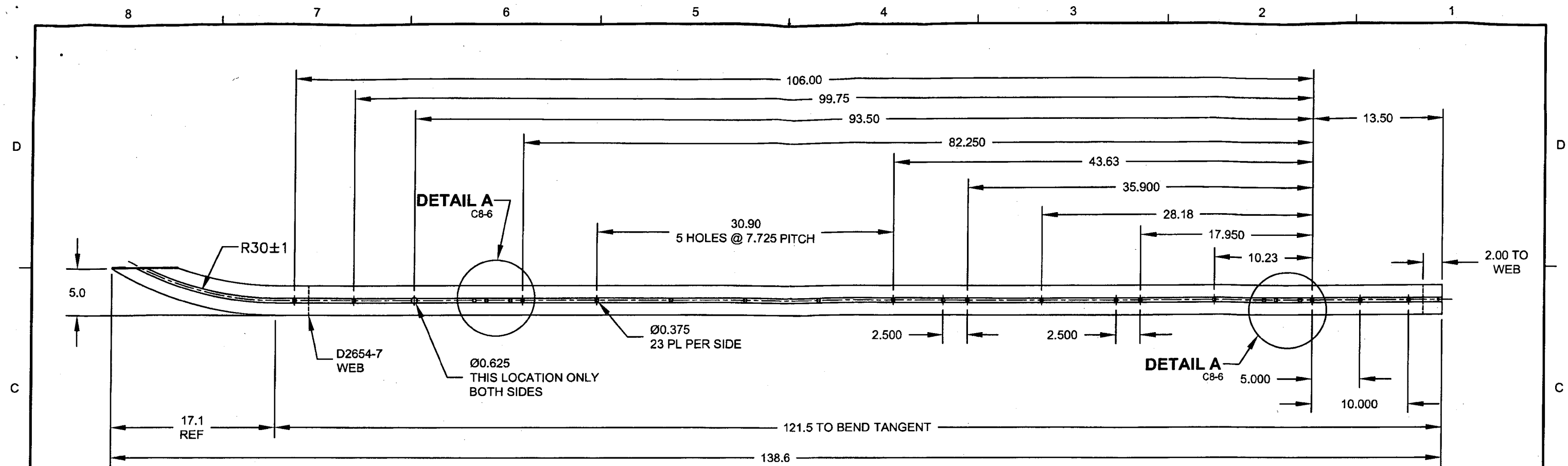


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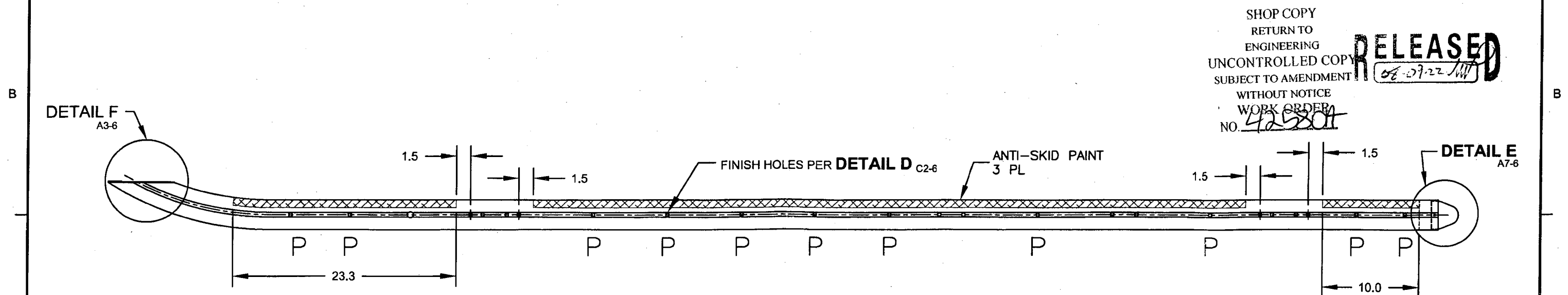
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### D2650-7 BENDING/DRILL DETAIL



## D2650-7 ASSEMBLY/FINISHING DETAIL

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